

Date: Monday, 9/18/2006 2:29:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 28641
 Estimate Number : 10775
 P.O. Number : N/A Part Number : D32081
 This Issue : 9/18/2006 S.O. No. : N/A Drawing Number : D3208 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 9/30/2006 Qty: 12 Um: Each
 Checked & Approved By : 06.09.19
 Comment : Est: B04.05.28 Material changed for Step 4KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet



Comment: Qty.: 0.1727 sf(s)/Unit Total : 2.0727 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)
 Note: To be made in multiples of 10
 Batch: M19295

FF 06.09.21 12

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 4.038" X 5.340" grain along 4.038"
 Identify for D3208-1

FF 06.09.21 12

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Drill and Fillet D3208-1 corner as per Dwg D3208
 Identify as D3208-1

FF 06.09.21 12

4.0	BRAKE NC	NC BRAKE
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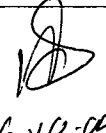


Comment: NC BRAKE
 Deburr D3208-1
 Form D3208-1 as per Dwg D3208
 Polish any marks on part within 01. of Dwg D3208

FF 06.09.21 12
 SB 06/10/04 11 P10
 FF 06.10.11 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/04	4	1 part was out of Tolerance		Scrap & destroy	SN 06/10/04	 06-10-04		 06-10-04

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28641

Part Number: D32081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 10-11 (11)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08/10/12

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

B 06/10/18

(11)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST415*

LB 06/10/18 (11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

Job Completion



W 06-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

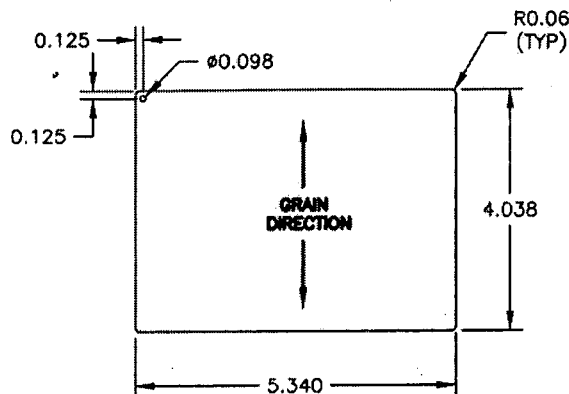
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

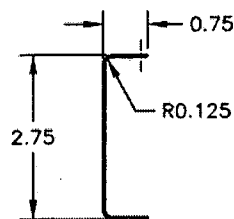


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	04.05.25	CHANGE DIM; NOTE 3) CHANGE	

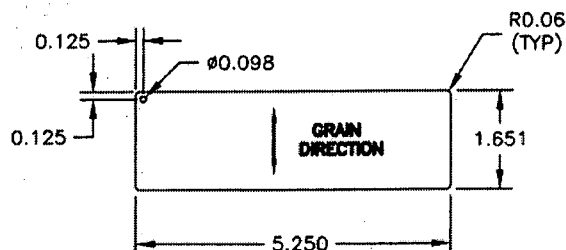
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04.04.05



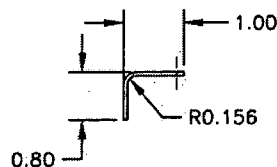
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)



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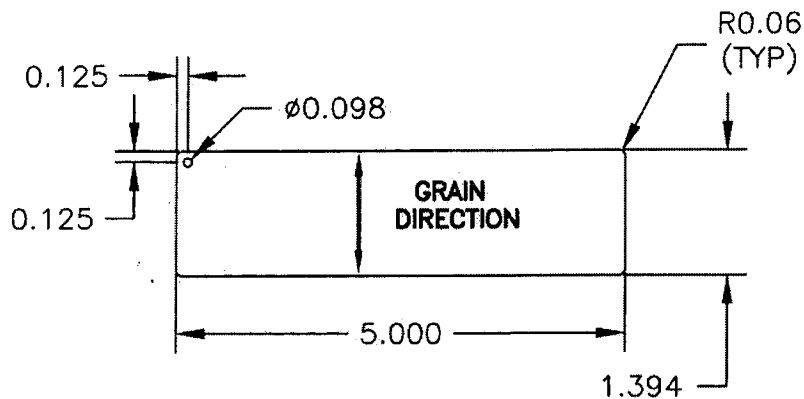
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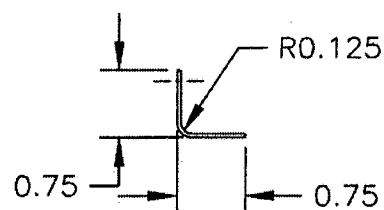


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

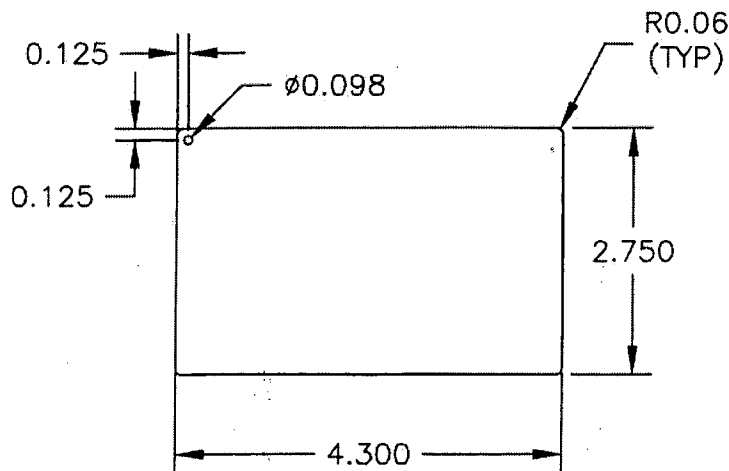
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04.04.05



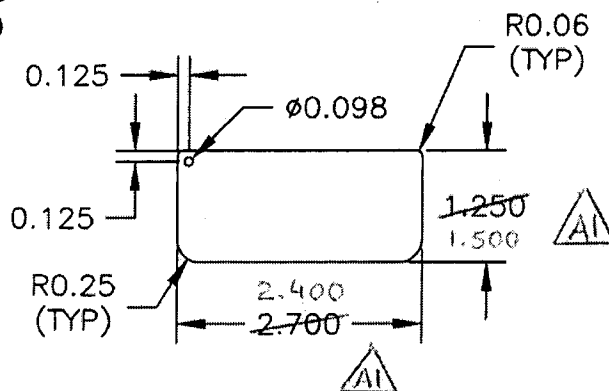
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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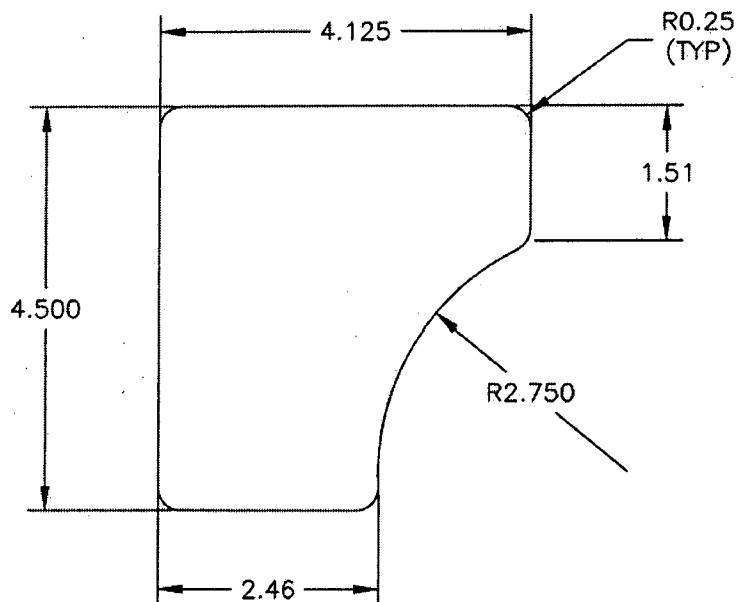
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05



D3208-9 DOUBLER

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